

Date: Friday, 10/12/2007 1:12:00 PM
 User: Chantal Lavoie

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	DOUBLER ASSEMBLY
Job Number :	35159		
Estimate Number :	12368		
P.O. Number :	N/A	Part Number :	D314010
This Issue :	10/12/2007	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3140 REV F
First Issue :	N/A	Project Number :	N/A
Previous Run :	32231	Drawing Revision :	F
	Type :	Material :	N/A
	SMALL / MED FAB	Due Date :	10/19/2007
Written By :			Qty: 2 Um: Each
Checked & Approved By :			
Comment :	Est: A 06.04.19 New Issue KJ Est Rev: B As per ECN #829 06-11-20 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D314085	Angle
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Angle

Batch

B 34831

FF

07-10-17

2

2.0	D314089	Doubler
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Doubler

Batch

B 34373

FF

07-10-17

2

3.0	MS20426AD34	RIVET
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Comment: Qty.: 5.0000 Each(s)/Unit Total: 10.0000 Each(s)

RIVET

Batch

M 102404

FF

07-10-17

2

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3140

FF

07-10-17

2

5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

10-10-01 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3140-10 PAR #: N/A Fault Category: Prod / FAB ASS' med & sm NCR: Yes No DQA: L Date: 07/11/06
 QA: N/C Closed: TS Date: 07.11.06

NCR: <u>35159</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-10-31	4.0	4 rivets are crooked, on the back side, and remaining rivets, aren't pressed enough. R.C: Bad installation	<u>OSWIL</u>	remove & replace Qty 4 m m10244 Flatten out remaining rivets .010" more.	<u>07/11-01</u> <u>FF.</u>	<u>07-11-01</u>	<u>OSWIL</u>	<u>07-11-01</u>

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER ASSEMBLY

Job Number: 35159

Part Number: D314010

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CL0711101 (2)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

D07/11/02

Job Completion



CL0711101

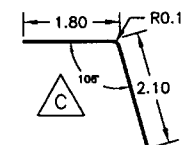
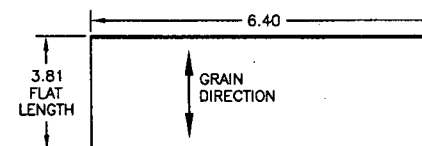
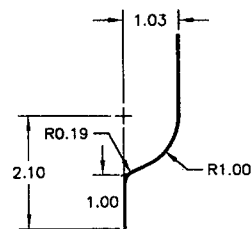
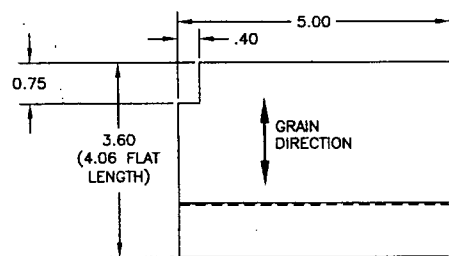
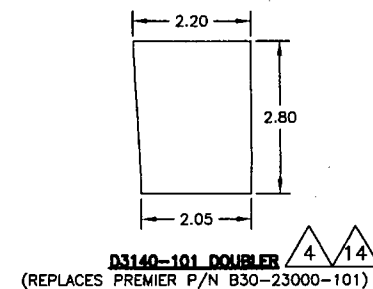
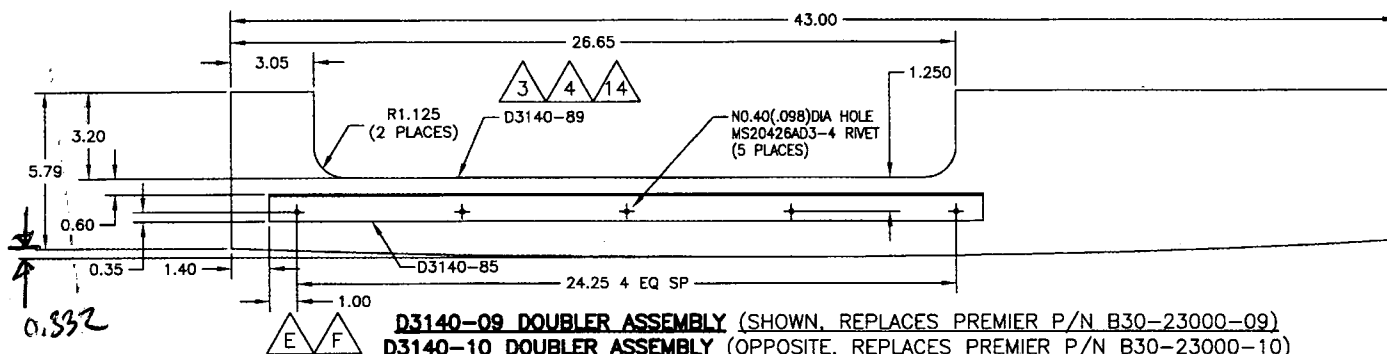
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

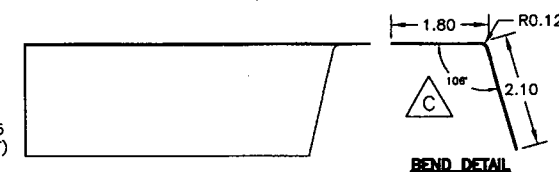
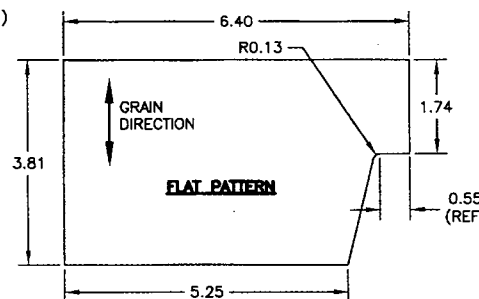
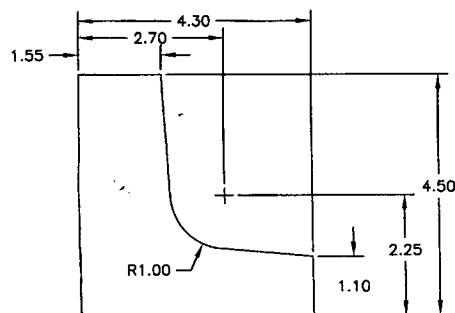
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3140-91F FLAT PATTERN
 (USE TO MAKE D3140-91/-92 DOUBLERS)

D3140-92 DOUBLER (SHOWN, REPLACES PREMIER P/N B30-23000-92)
D3140-91 DOUBLER (OPPOSITE, REPLACES PREMIER P/N B30-23000-91)



D3140-97 DOUBLER (SHOWN, REPLACES PREMIER P/N B30-23000-97)
D3140-98 DOUBLER (OPPOSITE, REPLACES PREMIER P/N B30-23000-98)

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DESIGN 4	DRAWN BY CB	DART DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3140
DATE 06.10.06	TITLE DOOR	REV. F SHEET 5 OF 7 SCALE NTS